

Work Order ID 81544

March-15-12 10:31:41 AM

81544

Page 1

Item ID: D3641-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover
 Start Date: 15/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3641	Rev C								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 B12-4-12
 FLOW CNC Waterjet 1-Cut as per Dwg D3641
 SSS, 032 Dwg Rev: E
 Prog Rev: E
 2-Deburr if necessary (18)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 B12-4-12
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 5/2/04/12 (18)
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3641-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover

Start Date: 15/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Form as per Dwg D3641-3

(13)

0

SB
12/04/12

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8.7/12/12

(14)
-3

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

(15)

2/6 12-4-17

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Page 3

Item ID: D3641-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover

Start Date: 15/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

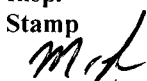
QC

Memo

0.00

Quality Control

18x 


12/04/17

170

Identify as per dwg & Stock Location **2600**

0.00

170

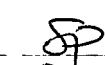
Packaging

Memo

0.00

Packaging

18x


12-01-17

180

QC21- Final Inspection - Work Order Release

0.00

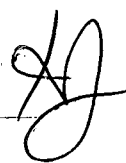
180


QC

Memo

0.00

Quality Control

12/4/17 


12-04-17

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

March-15-12 10:31:44 AM

Page 1

Work Order ID: 81544

81544

Parent Item: D3641-3

D3641-3

Parent Item Name: Cover

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	223.8000	0.7851	9.917053	14.5		

M5052H32S 032

5052-H32 .032 Sheet

B12-4-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	223.8	
112664	10.4	
115638	12	
116657	20.5	
117798	20.9	
121030	64	
121040	96	

121040

(18)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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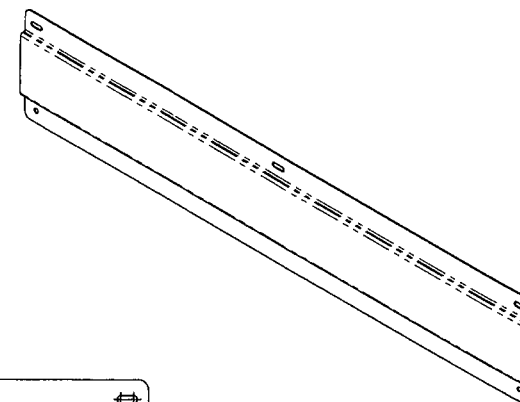
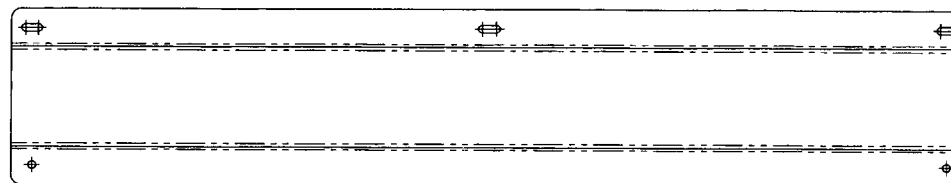
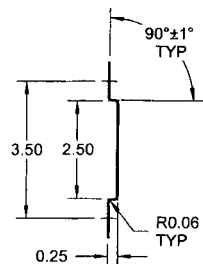
Dart Aerospace Ltd

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NOTE: Date & initial all entries



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
 2009-11-18

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

WITHOUT NOTICE
 WORK ORDER
 NO. 81544 MLC

12/03/15

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

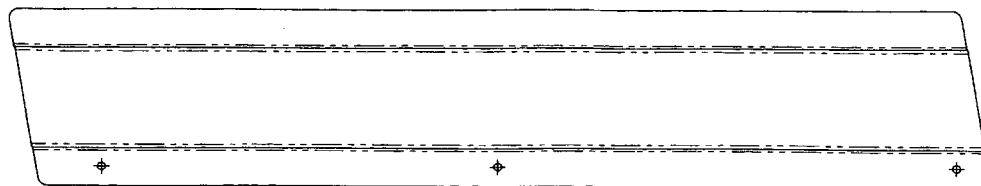
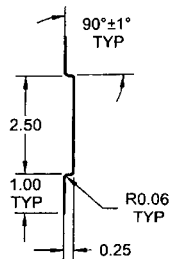
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

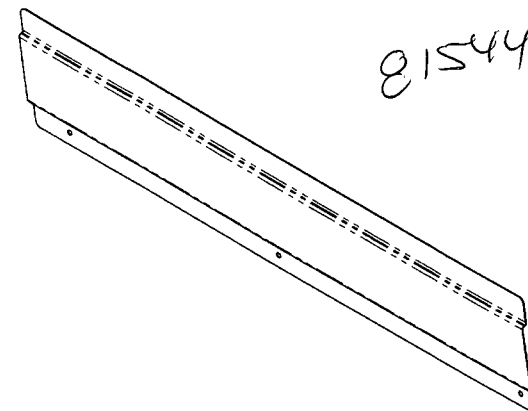
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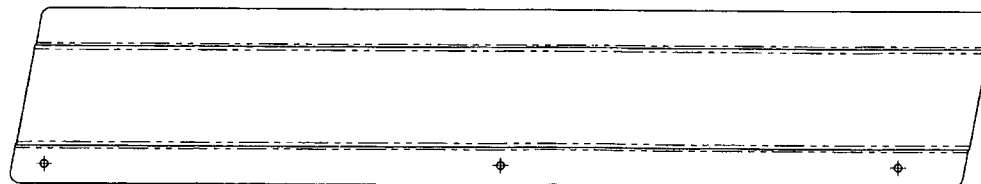
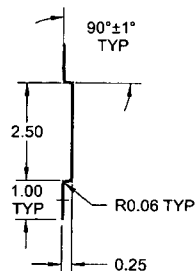
NOTE: Date & initial all entries



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
 (MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
 (MAKE FROM D3641-3F FLAT PATTERN)

RELEASED
 2009 -11- 10

NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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W/O:		WORK ORDER CHANGES					
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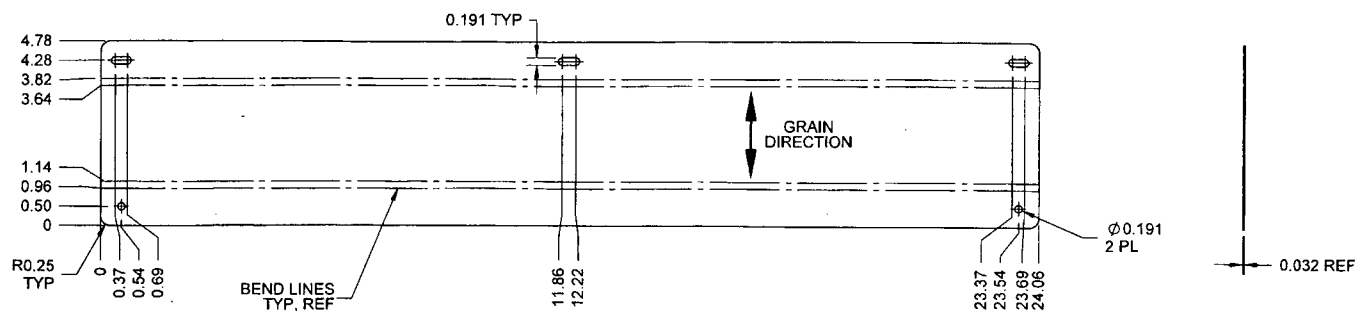
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

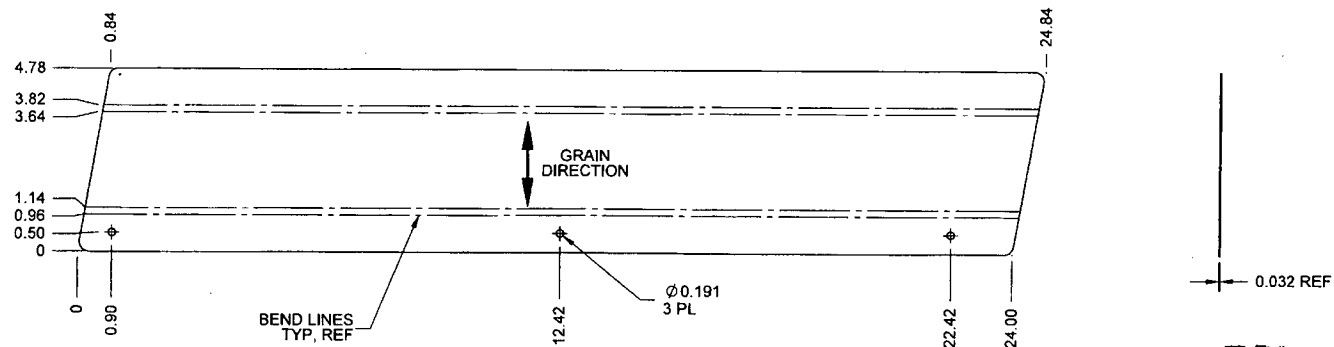
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81544



D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

RELEASED
2009-11-10

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	RF	D3641	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
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